



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB910-0020-1
Job Sheet 194906



Part No: RB910-0020-1

Job Qty: 6 pcs

Part Name: Quill



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/9/19

Job Tracking No:

Due Date: 7/11/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-154 - 1	6 pcs	7/11/19	7/11/19	0.00	0.00	SL-154 - 1		<i>[Signature]</i> 19/06/13
120	QC 2	6 pcs	7/11/19	7/11/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		<i>[Signature]</i> 19/06/13
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		



Container No: S190126



Part: RB910-0020-1

Job No: 194906

Serial No/Batch: S190126

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/13/19

130 QC 8	6 pcs	7/11/19	0.00 0.00	QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	2019-06-14
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
150 Outsource - 4 - Anodize	6 pcs	7/11/19		ATG001-VC Grocoo	2019-06-17
160 Packaging 2-1 - Receive - B4B	6 pcs	7/11/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	JUN 24 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	

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170 QC 6	6 pcs	7/11/19	0.00 0.00	Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	
180 Packaging 3-1 - Stock - B4B	6 pcs	7/11/19	0.00 0.00	QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				Packaging 3 - 1 - B4B	
190 QC 21 - SA	6 pcs	7/11/19	0.00 0.00	Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	6 pcs	7/11/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - CNC Lathe (MORI SL-154 LATHE) 1-Machine as per DWG. FB657 FOLIO REV: AA DWG REV: 9-89
 Descriptions: 2 2-Debur

120 - (QC2- Inspect parts off machine FAI/FAIB) Engrave T/N and/or P/N number using Marktronic engraver as per DWG.

130 - (QC8- Inspect parts - second check)

150 - Issue P/O to ATG: PO 43752 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RB910-0020-1 Rev. 2

160 - (Receive & Inspect for Damage & Mat'l Certs)

170 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location:)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.000	Round Bar 1.00"	2.0160 ft (.336 ea)	110-SL-154 - 1	<u>5157425</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	M6061T6R1.000	2	37	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order:	197906
Description: QUILL		Part Number:	RB910-0020-1
Inspection Dwg:	Rev: 2	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0,70	+ 0,010	0,702	✓		MJP-04	✓
0,250	+ 0,006	0,252	✓			
0,10 x 45°	- 0,001	0,100 x 45°	✓			
0,431	+ 0,010 ± 0,5°	0,432	✓			
0,431	+ 0,005	0,432	✓			
0,216	+ 0,005	0,216	✓			
0,810	+ 0,005	0,810	✓			
0,25	+ 0,010	0,250	✓			
0,212	+ 0,005	0,215	✓			
0,052	+ 0,005	0,050	✓			
1,538	+ 0,005	1,537	✓			
0,322	+ 0,005	0,320	✓			
0,100	+ 0,005	0,101	✓			
1,020	+ 0,005	1,018	✓			
0,434	+ 0,005	0,434	✓			
0,498	+ 0,001	0,499	✓			
0,470	+ 0,000	0,466	✓			
0,300	+ 0,005	0,301	✓			
0,080	+ 0,005	0,080	✓			
1,35	+ 0,010	1,350	✓			
0,500	+ 0,005	0,499	✓			
(0,680)	+ 0,005	0,681	✓			
0,140	+ 0,005	0,142	✓			
1,802	+ 0,005	1,801	✓			
0,150	+ 0,005	0,149	✓			
0,159	+ 0,005	0,160	✓			
0,20	+ 0,010	0,200	✓			
3,832	+ 0,005	3,834	✓			

Measured by: MJP	Checked by: [Signature]	QC Inspector:
Date: 19/06/13	Date: 19/06/14	Date:

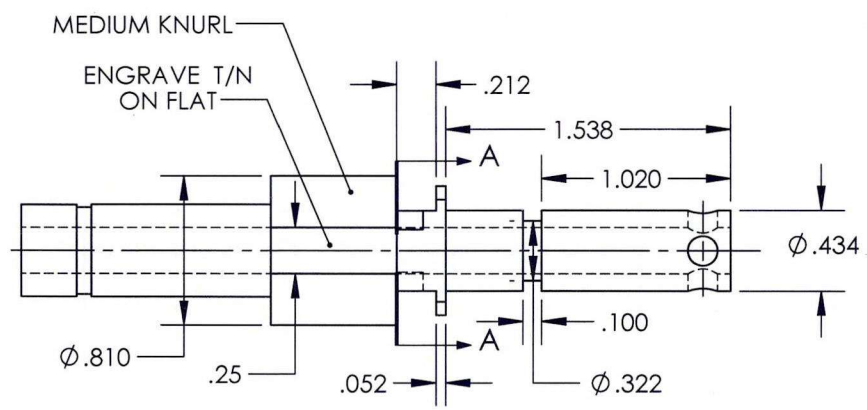
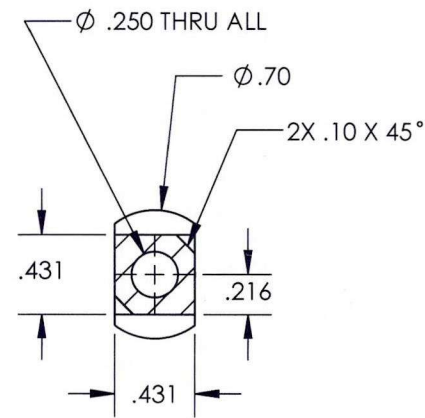
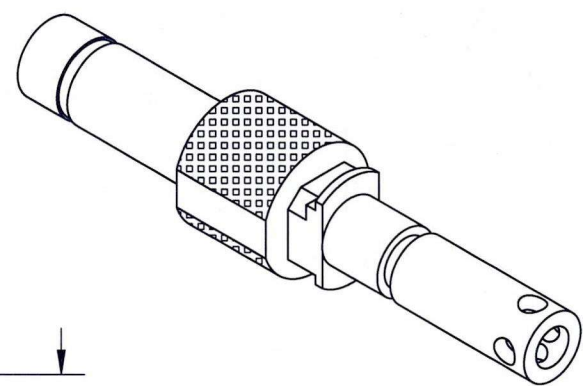
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

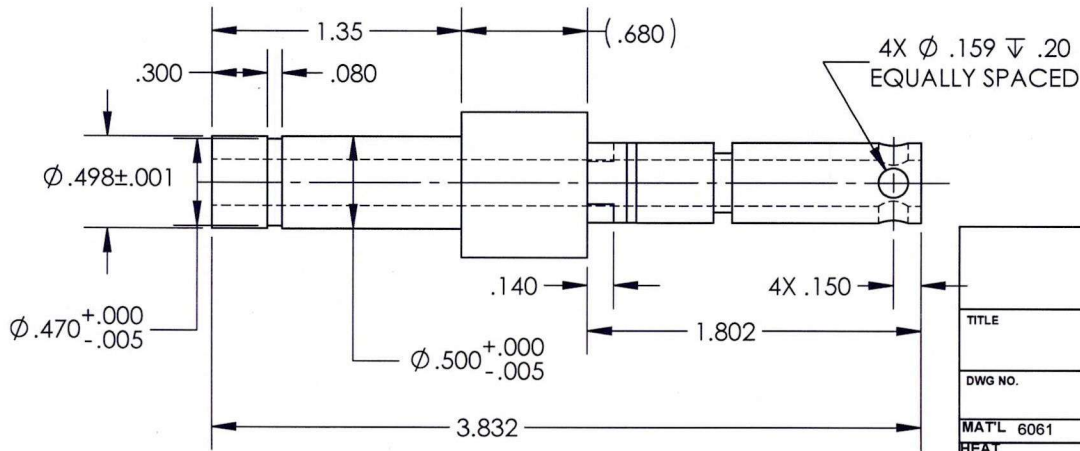
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL

SEE ATTACHED DEVIATION



SECTION A-A
SCALE 1 : 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194906 MJS
19-05-09

(-1)
FITTING

DART AEROSPACE	
TITLE DRAIN HOSE	
DWG NO. RB910-0020-1	REV 2
MAT'L 6061 HEAT TREAT FINISH RED ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS II	
DRAWN BY: GILBERT CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: MACKOVJAK	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 10/8/2012
SHEET 2 OF 2	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043752



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043752

PO Date: 6/17/19

Due Date: 6/24/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-18

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193763	C2-1-1	Manual Release Knob (Outsource process- Anodize per QSI017 4.1.10.1)-Issue PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	6/24/19	10 pcs	0 pcs	10 pcs	\$2.8571/pcs	\$28.57
							10 X JUN 24 2019				
2	194906	RB910-0020-1	Quill -Issue PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RB910-0020-1 Rev. 2	Firmed	-	6/24/19	16 pcs	0 pcs	16 pcs	\$2.8571/pcs	\$45.71
							16 X JUN 24 2019				
3	193169	RBE350A93-3205-00E	Engine Gear Box Input Flange Holding Wrench -Issue PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A93-3205-00E Rev. 2A	Firmed	-	6/24/19	16 pcs	0 pcs	16 pcs	\$2.8571/pcs	\$45.71
							16 X JUN 24 2019				

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Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043752



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	193171	RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench -Issue P/O: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C	Firmed	-	6/24/19	16 pcs	0 pcs	16 pcs	\$4.50/pcs	\$72.00
5	193358	RBE350A93-3302-02-1	Handle (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3302-02-1 Rev. 11 -Certificate of Conformity is required	Firmed	-	6/24/19	12 pcs	0 pcs	12 pcs	\$5.49/pcs	\$65.88
6	195093	RBE350A93-3712-00-22	Stop -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	6/24/19	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
Grand Total:											\$377.88



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043752



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/18/19 9:23 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020078-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupepaltech.com

Bon de Livraison / Packing Slip

020078- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
19-Jun-2019		SVETLANA DORZHIYEVA		POHB043752 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C2-1-1 ✓ Rev.	C2-1-1 01 -ANO-RED [ANODIZE RED] AS PER IAW MIL-A-8625 TYPE 2, CLASS 2 WATER SEALANT	ANODIZE CH	10	10 ✓	0	0	0
2	RB910-0020-1 ✓ Rev.	RB910-0020-1 01 -ANO-RED [ANODIZE RED] AS PER IAW MIL-A-8625 TYPE 2, CLASS 2 WATER SEALANT	ANODIZE CH	16	16 ✓	0	0	0
3	RBE350A93-3205-00E ✓ Rev.	RBE350A93-3205-00E ANODIZE RED AS PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	16	16 ✓	0	0	0
4	RBE350A93-3205-00T ✓ Rev.	RBE350A93-3205-00T ANODIZE BLACK AS PER MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	16	16 ✓	0	0	0
5	RBE350A93-3302-02-1 ✓ Rev.	RBE350A93-3302-02-1 ANODIZE BLACK AS PER MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	12	12 ✓	0	0	0
6	RBE350A93-3712-00-22 ✓ Rev.	RBE350A93-3712-00-22 01 -ANO-CLEAR [ANODIZE CLEAR] AS PER IAW MIL-A-8625 TYPE 2, CLASS 2 WATER SEALANT	ANODIZE CH	6	6 ✓	0	0	0

 DAS
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RECEIVED
 JUN 21 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.